

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017696**Date Inspected:** 29-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

1). OBG Field Splice 4E/5E Weld ID: ALS3 - (SMAW)

2). OBG Field Welding of East Line Lifting Rod Access Penetration Insert (SMAW)

1). OBG Field Splice 4E/5E Weld ID: ALS3 - (SMAW)

The QAI periodically observed AB/F approved welder Hua Qiang Hwang (ID 2930) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position. Mr. Hua Qiang Hwang was welding root, fill and cover passes on face B and later in the shift was welding cover passes on face A at ALS3. Back grinding was previously completed on 9/8/10 at this stiffener location. QC Inspector John Pagliero was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1012-3. The QAI observed that the welding at this location was completed and the 100°C post heat was in process at the end of the shift. The QAI observed that the work at this location appeared to be in general compliance with contract documents.

2). OBG Field Welding of East Line Lifting Rod Access Penetration Insert (SMAW)

Interior: OBG 1E-PP9.5-E3-weld 1

The QAI periodically observed the welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position to restore the Lifting Rod Access Penetrations in the A deck at PP9.5. The QAI observed that AB/F approved welder Darcell Jackson (ID 9967) performed back grinding and subsequent back welding at PP9.5 weld E3-1. See photo below. QC Inspector Patrick Swain was periodically present to monitor the progress and

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verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1110B rev 1. The QAI periodically observed QC Inspector Patrick Swain performing Magnetic Particle Testing (MT) of the back grind areas prior to back welding at this location. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Welding was completed at this location and the QAI observed that the work appeared to be in general compliance with contract documents.

Interior: OBG 3E-PP17-E3-welds 2 & 4

The QAI periodically observed the welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position to restore the Lifting Rod Access Penetrations in the A deck at PP17. The QAI observed that AB/F approved welder Eric Sparks (ID 3040) performed back grinding and subsequent back welding at PP17 welds E3-2 and E3-4. See photo below. QC Inspector Patrick Swain was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1110B rev 1. The QAI periodically observed QC Inspector Patrick Swain performing Magnetic Particle Testing (MT) of the back grind areas prior to back welding at these locations. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Welding was completed at this location and the QAI observed that the work appeared to be in general compliance with contract documents.



Summary of Conversations:

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer